<b>Work Order ID 99671</b> <i>April-11-13 2:39:44 PM</i>				*996					Page 1		
Revision ID:	D4004-11 Top Strap Att	ach Bracket $\mathcal Q$	A	Accept	*N900	<b>040</b>	100	)* s	etup Start	I VI	S1* S2*
	4/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:		,	· .		. 17
Approvals:	Process Pla	an: MLJ	Date: <u>  אט-</u>	Tooling:	Da	ite:	· ·	R	tun Star	1/1	R1*
-FF-			Date:		Da	ite:			Stop	*N	R2*
equence ID/ Vork Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D4004	X	B BL							·		
00 <b>*100*</b> Bandsaw		BAND SAW Memo		0.00	je k			E 8	3 ø	·	
Jeaspa Bandsaw		1-Cut D30	is started at correct place	n per D4004-11 detail of dv	wg D4004 MJP	13/0	4/23	•			
		2-Deburr	**								
105				0.00				$\circ$			9
*105* Small Fab		Memo		0.00				X_			4)L
Small Fab		Drill and o	sink holes as per dwg and	I trim part to lenght as requ	iired.						

*‡* 

NCR: Ye	es / No				WORK ORDER NON-	CON	<b>VFORI</b>	MANCE / UP	DATE			
	,									QA Closed:	Date	:
Work Order	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	, manual
	· · · · · · · · · · · · · · · · · · ·			<del></del>	Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part No	0.				Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		i			Use-as-is			noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR No	0	:			Work Order Update	J		Large Fab	Composite	]	Supplier	
Root				Descri	ption of work order update	1	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1										İ
Equip/Tooling	<u></u>	1				ŀ						
Operator	_											,
Material	_											<b>,</b> '
Setup	_	1							×			
Other	_											1
Process	_		,			ļ						
Supplier	_			·								
Training									-	,		
Unapproved		<u> </u>	<u> </u>	<b>i</b>		- 0111	TCATE	CORV		<u> </u>		1
		-1			General	AUL	T CATE	GURT				:
Landing	Bending	!			Bend		Grain			Ovalized	Γ	Pressure/Forced
	Centre No	et Conso	ntric to	0/5	BOM/Route	$\vdash$	Hardwa	aro.	<u> </u>	Over/Under	tolerance	Temperature/Cure
-	Cracks	or concei	וונוונ נט	U/3  -	Broken/Damaged	-		ion Incomplete	-	Part Incorre	F-	Weld
<u>"</u>  -	Crushed/0	Crimpad			Burrs	-		tions Incomplete/	Unclear	Part Lost/M	<u>-</u>	Wrong Stock Pulled
F	Cuffs	i į	•		Contamination		Mainte			Part Moved		
,  -	Heat Trea	l Iti		-	Countersink	$\vdash$	Mislabe		-	Positioned V	Vrong	 
F	Inspection		Tube	<u> </u>	Cut Too Short		Misrea			Power Loss/		Other
	Ripples in				Drill Holes		Offset		L	·	·	
F	Torque W		Extrusio	n	Drawing		i	Calibration				1
<b> </b>	Turning S				Finish		4	Sequence				i
<u> </u>	<b>—</b>	i		<u> </u>	<b>-</b>		1					

Outside Dimensions

DQA: \_\_\_\_\_ Date: \_\_\_

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	<b>Work Order ID 99671</b> <i>April-11-13 2:39:44 PM</i>			*990	671*				Pag	ge 2
Item ID: Revision ID:	D4004-11			Accept	*N900040	1100	* Se	etup Start Stop	14.51	
Item Name: Start Date: Required Date: Reference:	Top Strap Att 4/11/13 4/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	·	Cust Item ID: Customer:				*NS2*	
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:		R	un Start Stop	"NKT	*
Sequence ID/ Work Center II	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty		Reject Insp. Number Stamp	: )
*110* QC Quality Control		Memo		o.oo 13 4	125		_8_			<del>-</del> -
120		Chemical Conversion Co	oat per QSI005 4.1	0.00			Ci.	a 1	2.00	
*120* HandFinish Hand Finishing		Мето		0.00			_8_	MG)	13476	<u></u>

0.00 **AS** 27 0.00 **B** 4 **26** 

130

\*130\*

Quality Control

QC3- Inspect Part Finish

Memo

NCR: Ye	es / No	1			WORK ORDER NON-	CONFOR	MANCE / UI	PDATE			•
									QA Closed:	Date	):
Work Orde	r:				DISPOSITION	_		AGAINST DI	EPARTMENT,	/PROCESS	
Part N	0.				Rework Scrap		Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o	· · · · · · · · · · · · · · · · · · ·			Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root .				Descri	ption of work order update	Initial	А	ction	Sign &		1
Cause	Date	Step	Qty	ļ	or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											1
quip/Tooling		1									;
Operator											1
Material				,							
ietup											
Other		1									: 1
rocess		1									
Supplier		!									ı
raining											
Inapproved			<u> </u>								
					F	<b>AULT CAT</b>	EGORY				
Landin	g Gear				General				_	_	
. [	Bending	1			Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to C	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
Γ	Cracks	!			Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instru	ctions Incomplete	e/Unclear	Part Lost/M	íssing	Wrong Stock Pulled
Γ	Cuffs	İ			Contamination	Maint	enance		Part Moved		
Γ	Heat Trea	at			Countersink	Mislat	eled		Positioned \	Wrong	<u> </u>
ľ	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	ad		Power Loss/	/Surge	O'ther
T	Ripples in	1			Drill Holes	Offset			<del></del>		1
ľ	Torque W	√av¦es in E	Extrusion		Drawing	Out of	Calibration				:
Ī	Turning S	1			Finish	Out of	Sequence				
ľ	Wave/Tw				Folio	Outsic	le Dimensions				

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-11-13 2:3	89:44 PM												
Item ID: Revision ID:	D4004-11			Accept	*N900	<b>040</b>	100	)*	Setup	Start	*N:	S1*	
Item Name:	Top Strap At	tach Bracket								Stop	*N.	S2*	
Start Date:	4/11/13	Start Qty: 4.00	*4*		Cust Item II	D:							
Required Date:	: 4/11/13	Req'd Qty: 4.00	*4*		<b>Customer:</b>								
Reference:							_			644			
Approvals:	Process Pl	an:	Date:	Tooling:	Da	te:	<b>.</b>		Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	Da	te:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	-	Reject Number	Insp. Stamp	
140		Identify as per dwg & St	tock Location:	0.00								7 ,	_
*140* Packaging		Memo	57243	0.00					<i>,</i>	/10	<sup>†</sup> /3/	1/29 (	F
Packaging													
150		QC21- Final Inspection	- Work Order Release	0.00							1	da	
*150*								-		191	5/0	7/2)	
QC		Memo		0.00						·	-t		
Quality Control											$\mathcal{C}$	nur a U-S	
												- U-	9

NCR:	Yes	/ No	!			WORK ORDER NON-C	CONFOR	MANCE / UP	DATE		_	
				-		· · · · · · · · · · · · · · · · · · ·				QA Closed:	Da	te:
Work Orde	er: _					DISPOSITION			AGAINST DE	PARTMENT	-	
Part N	No.					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality
NCR 1	No.					Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	
Root					Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verificatio	n QC Inspector
Doc/Data					·							<u> </u>
Equip/Tooling	Ш		1									\$ 53.
Operator												
Material	Ш											
Setup	Щ											
Other			1 :									
Process	Щ				!					İ		
Supplier								]		ļ		1
Training	$\sqcup$		1 1									
Unapproved	Ш		<u> </u>				1			<u> </u>	<u> </u>	
			<u> </u>			<del></del>	AULT CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landi			1		_	General	<u></u> .		_	1		[] <sub>0</sub>
		Bending			. <b>L</b>	Bend	Grain		-	Ovalized		Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	Hardw		<u> </u>	Over/Under		Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	<b>⊢</b>	tion Incomplete	<u></u>	Part Incorre		Weld
		Crushed/	Crimped.	•		Burrs	<b>—</b>	tions Incomplete/	Unclear	Part Lost/M	-	Wrong Stock Pulled
	$\vdash$	Cuffs			<u> </u>	Contamination	$\vdash$	enance		Part Moved		
		Heat Trea			<u> </u>	Countersink	Mislab			Positioned \		
		Inspection	1 .	Tube	<u> </u>	Cut Too Short	Misrea	d	<u> </u>	Power Loss,	/Surge	Other
	${f -}$	Ripples in	,		<u> </u>	Drill Holes	Offset					
	—	Torque W	ŀ		n	Drawing	$\vdash$	Calibration				
	Ш	Turning S	equence			Finish	$\vdash$	Sequence				
	ll	Wave/Tw	ist in Tul	oe e		Folio	I Outsid	e Dimensions				!

DQA: \_\_\_\_ Date: \_

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

April-11-13 2:39:43 PM

Work Order ID:

99671

Parent Item:

D4004-11

Parent Item Name:

Top Strap Attach Bracket

**Start Date:** 4/11/13

Required Date: 4/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 09.12.15 new issue EC verified by:DD

IPP Rev:B 10.05.17 as per ECN10-

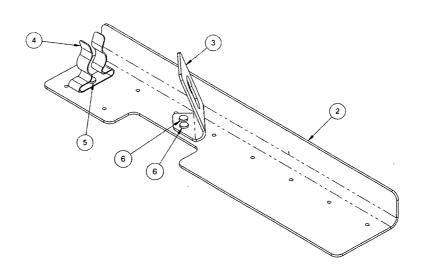
	362 DD veri:EC	IPI	Rev:C I	2.03.07 as per	r awg rev.b DD	veri: EC							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
40456-11-144		Purchased	No	<del></del>	<del>, ,, </del>	100	f	0.0000	0.41	1.726315	6		1
SEAT TRACK									02 J= .:=		· · · · · · · · · · · · · · · · · · ·		

D3033-144 B84257 2,6666

									DQA:	Date		
NCR: Y	'es / No				WORK ORDER NON-C	CONFO	RMANCE / UP	DATE	QA Closed:	Date		<u>,</u>
Work Orde	).r·				DISPOSITION			AGAINST DI	EPARTMENT,	/PROCESS		
Part N	lo.				Rework Scrap Use-as-is Work Order Update	The	Skid-tube  Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					ption of work order update	Initial		ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Er	ig Desc	cription	Date	Verification	QC Inspector	
Doc/Data	_										, i	
Equip/Tooling Operator	$\dashv$										1	
Material												
Setup												
Other	-											
Process						-					1	
Supplier		1									1	
Training											:	
Unapproved			<u> </u>								.   _	_
					F.	AULT CA	regory					
Landir	ng Gear	Ì			General				_	_	; -	
	Bending	;			Bend	Grain	ı		Ovalized		Pressure/Forced	
	Centre (	Not Conce	entric to	o/s	BOM/Route	Hard			Over/Under	<b>⊢</b>	Temperature/Cure	
	Cracks	[			Broken/Damaged		ction Incomplete	<u> </u> _	Part Incorre	<b>├</b>	Weld	
	<del> </del> !	l/Crimped	l.		Burrs	$\vdash$	ictions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	<del>  </del>	itenance	_	Part Moved		1	
	Heat Tre	eat			Countersink	$\rightarrow$	beled	<u> </u>	Positioned V		<b>-</b>	
		on Strip ir	1 Tube		Cut Too Short	Misro		L	Power Loss/	'Surge	Other	
	Ripples				Drill Holes	Offse					j	_
	Torque	Waves in	Extrusio	n L	Drawing		of Calibration				!	
Į		Sequence			Finish	<b>⊢</b> —1	of Sequence					_
	Wave/T	wist in Tu	be		Folio	Outs	de Dimensions				:	

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ITEM NO.	QTY, -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	, SIDE RESTRAINT	The second secon
3	1	D4004-3	ANGLE	The state of the s
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	



UNCO I SUBDICT: V3 F, 3 NO 996714U 13-04-16

С

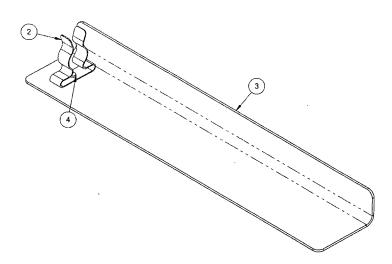
#### **D4004-041 SIDE RESTRAINT ANGLE**

NOTES: 1) MATERIAL: N/A 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3,5.15) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 7) WEIGHT: 0.21 lbs	3
--	---

В	CHANG *ANSI 6	E POWDER C	OAT FROM "GREY SANDTEX" TO 8-1, ZN A8-2.	DC	12.02.27		
A	NEW IS	SUE		HS	10.02.10		
REV.			DESCRIPTION	BY	DATE		
DESIG	N .	<b>3</b> 5	DART AEROSP	ACEL	TD		
DRAW	N	DC	HAWKESBURY, ONTAI				
CHECK	ED	<b>4</b> 5	DRAWING NO.		REV. B		
MFG. A	PPR.	星	D4004	,	SHEET 1 OF 11		
APPRO	VED	NB	TITLE		SCALE		
DE APF	PR.	-#	SIDE RESTRAINT		NTS		
DATE	12.0	2.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD  PHIS DOCUMENT IS PRIVATE AND COMPRESHING AND IS RUPPLED ON THE EXPRESS CONCINION THAT IT  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WITH PERSONNERS FROM DAYS AND PROPERS.				

В

	ITE	M NO	,,	QTY. -043	PART NUMBE	R .	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
	!	1		X	D4004-043	SIDE	RESTRAINT ANGLE AND TIE DOWN POIN	IT JCA-M47-2-04
		2		1_	D4004-7	HOSE	ECLIP	
D		3		1	D4004-9	ANGL	E	
_		4		11	MS20426AD4	RIVE	Г	



## D4004-043 SIDE RESTRAINT ANGLE AND TIE DOWN POINT

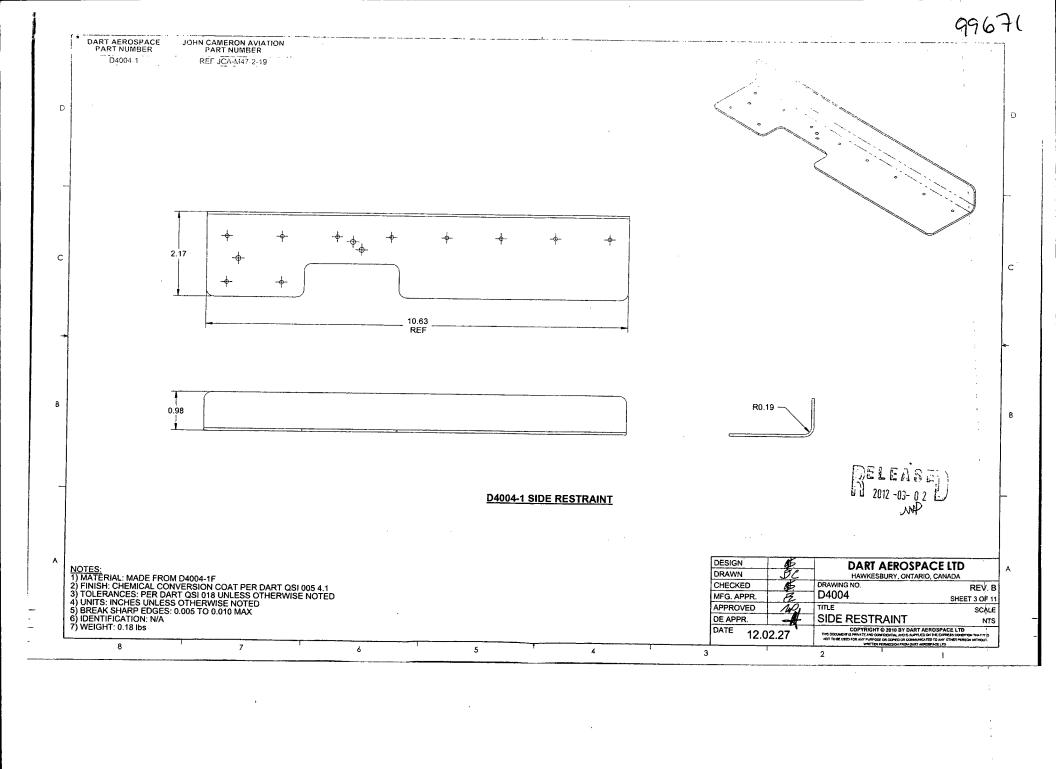


1) MATERIAL: N/A	
2) FINISH: POWOED COAT TANSI 61 CREV! (4.2 5.45) DED DADT OOL 007.40.	
2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 (B) 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	۷
4) UNITS: INCHES UNLESS OTHERWISE NOTED	
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX	
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1	
7) WEIGHT: 0.20 lbs	

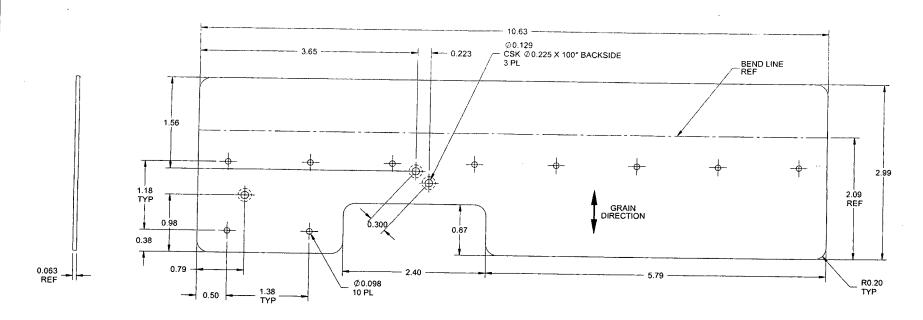
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4	 

DESIGN	<b>A</b>	DART AEROSPA	CELID
DRAWN	DC	HAWKESBURY, ONTARIO	
CHECKED	85	DRAWING NO.	REV. B
MFG. APPR.	E	D4004	SHEET 2 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	-	SIDE RESTRAINT	NTS
DATE 12.02.27		COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS COCUMENT IS FIRMATE AND CONFERENCE, AND IS SUPPLED ON THE EDITIESS CONSIDER THAT IT IS  HIGH TO BE LIED FOR ANY PROPESS ON COMPANIENT DE TO ANY OTHER PERSON WITHOUT	



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**D4004-1F FLAT PATTERN** 

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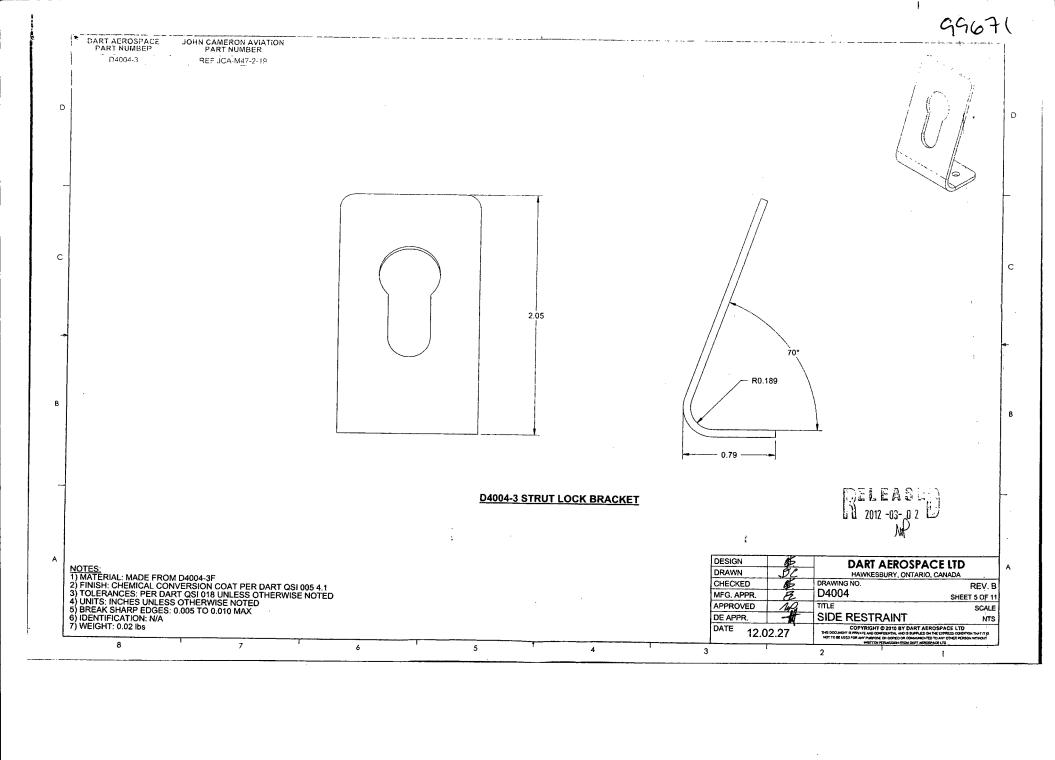
NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

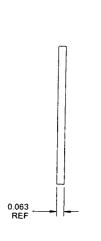
DATE

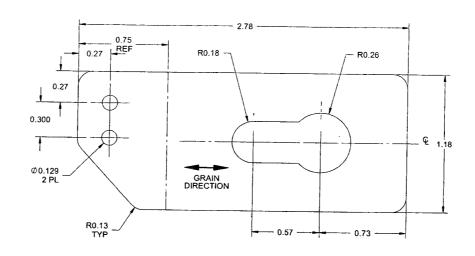
DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4004 MFG. APPR. SHEET 4 OF 11 TITLE APPROVED SCALE SIDE RESTRAINT DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD 12.02.27

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В





**D4004-3F FLAT PATTERN** 

NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

С

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4004 MFG. APPR. SHEET 6 OF 11 TITLE APPROVED SCALE SIDE RESTRAINT DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD

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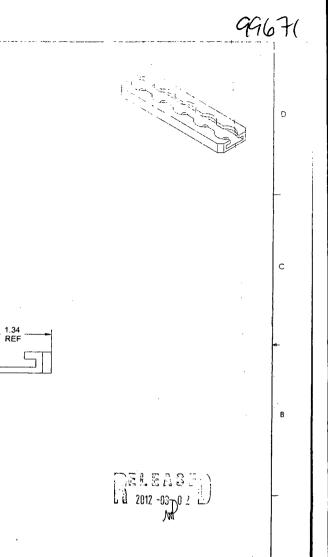
THE TROCARD THE ARRESTS OF THE PURPOSE OF THE ARRESTS OF THE PURPOSE OF THE PUR DATE 12.02.27

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#### D4004-5 BOTTOM STRAP ATTACH BRACKET

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6

DRILL Ø0.129 (#30 DRILL) CONCENTRIC WITH SEAT TRACK CSK Ø0.225 X 100° 5 PL

-CHAMFER 0.15 X 45° TYP

0.37 REF

	NOTES:
	1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
	OR BROWNLINE P/N 20276-144-0-0
	OR D3033-144
	2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
	3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
i	4) UNITS: INCHES UNLESS OTHERWISE NOTED
1	5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
	6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
	7) WEIGHT: 0.14 lbs

DART AEROSPACE PART NUMBER

D4004 5

D

С

Α

JOHN CAMERON AVIATION PART NUMBER JCA M47 2-23

DESIGN	<b>S</b>	DART AEROSPA	CELTD	
DRAWN	DC	HAWKESBURY, ONTARIO		
CHECKED	85	DRAWING NO.	REV. B	
MFG. APPR.	B	↑D4004	SHEET 7 OF 11	
APPROVED	14	TITLE	SCALE	
DE APPR.	-4	SIDE RESTRAINT	NTS	
DATE 12.02.27		COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT OF PRINTE AND CONFIDENTIAL AND IS EXPPLIED ON THE EXPRESS CONDITION THAT IT IS  MOT TO BE USED FOR ANY PURPOSE OR COMPANY OF TO ANY OTHER PERSON WITHOUT  WHITHIN PROMISSION FOR DOMET AND PARKELL ID.		

DART AEROSPACE PART NUMBER

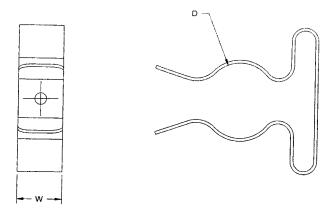
JOHN CAMERON AVIATION PART NUMBER

D40C4.7

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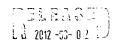
- REF JCA-M47-2-19

# **SPECIFICATION CONTROL DRAWING**



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS TUBE Ø	WIDTH "W"
D4004-7	MCMASTER-CARR	1722A42	NICKEL PLATED STEEL	0.31 - 0.75	0.38

**D4004-X HOSE CLIP** 



- 1	NOTES:
1	1) MATERIAL: SEE TABLE
١	2) FINISH: N/A
١	3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
1	4) UNITS: INCHES UNLESS OTHERWISE NOTED
1	5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
1	6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
١	7) WEIGHT: 0.01 lbs
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D4004 DESIGN DRAWN CHECKED REV. B MFG. APPR. SHEET 8 OF 11 APPROVED TITLE SCALE SIDE RESTRAINT NT:

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